

(1a)

Date: Friday, 8/3/2007 9:23:58 AM
 User: Jean-Luc Menard

Process Sheet

Next

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JACK SADDLE
Job Number	: 33828		
Estimate Number	: 11177		
P.O. Number	: N/A	Part Number	: D2281
This Issue	: 8/3/2007	Drawing Number	: D2281 REV G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 8/3/2007	Drawing Revision	: G
Previous Run	: 33414	Material	: N/A
Written By	: <u>SL/67-08-B.</u>	Due Date	: 8/10/2007
Checked & Approved By	:	Qty:	60 Um: Each
Comment	: Est Rev: A Removed from 9 Digit 05-12-02 JLM Est: rev B 06.07.17 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S14GA	304SS .080
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Comment: Qty.: 0.1313 sf(s)/Unit Total: 7.8750 sf(s)

304SS .080

batch: M105112 IB 07-08-S

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: GProg Rev: GIB 07-08-05

2-Deburr if necessary

Q.M 07.08.07

(63)

(63)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-08-05

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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(63)

Comment: SECOND CHECK

En 07/08/07

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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?

Comment: Deburr

Q.M07.08-0763

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 33828

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SR 07/08/07 (63)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/08 (63) count

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: PS 6

07/08/08 (63)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/09

Job Completion



07/08/09

DART AEROSPACE LTD		Work Order:	
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.470	X			
4.114	+/-0.010	4.114	X			
2.933	+/-0.010	2.935	X			
1.535	+/-0.010	1.540	X			
0.354	+/-0.010	-0.354	X			
0.354	+/-0.010	0.354	X			
0.604	+/-0.010	0.610	X			
2.000	+/-0.010	2.000	X			
3.396	+/-0.010	3.396	X			
3.646	+/-0.010	3.646	X			
4.000	+/-0.010	4.006	X			
1.525	+/-0.010	1.529	X			
2.475	+/-0.010	2.475	X			
Ø0.323	+0.006/-0.001	0.323	X			
0.080	+/-0.010	0.078	X			

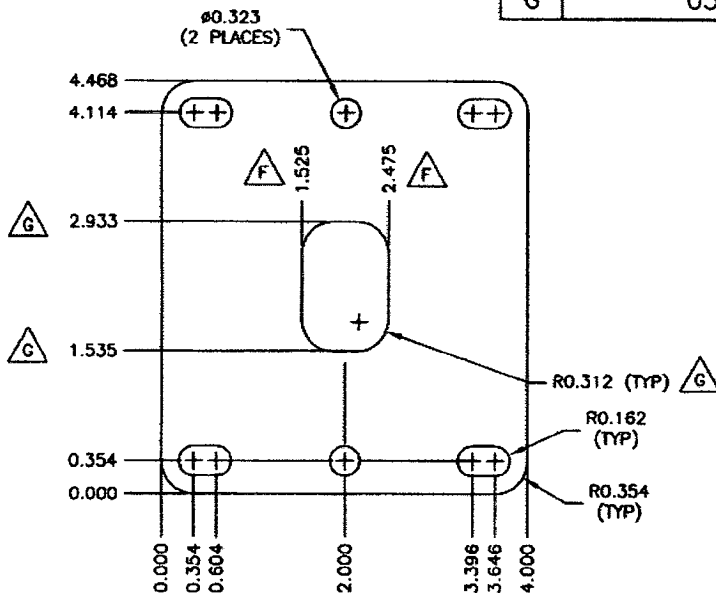
Measured by: B	Audited by: En	Prototype Approval:	N/A
Date: 07-08-05	Date: 07/08/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

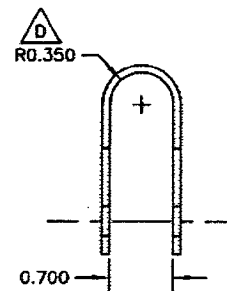
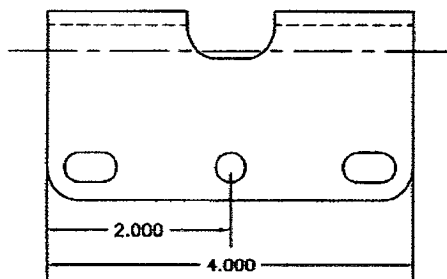


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11



FLAT LAYOUT



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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